

Work Order ID 132374 -2

132374

Page 1

Item ID: D2932-2

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Saddle RH Out, 206

Start Date: 5/07/15 Start Qty: 8.00

8

Cust Item ID:

Required Date: 5/07/15 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: *W*

Date: _____

Tooling: _____

Date: _____

Run Start *NR1*

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2932

Rev C

100

0.01

100

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.11

HAAS CNC vertical machine #1

Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per

108

DAS

20

9-89

DAS

44

9-89

15/05/27

15/05/28

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.28

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

108

DAS

44

9-89

15/05/28

120

0.00

120

QC1 - Inspection performed by CMM

QC

Memo

0.00

Quality Control

108

DAS

44

9-89

15/05/28

15/06/02

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
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				Completed By																					
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				QC / QA Coordinator Approval																					
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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____																		

Work Order ID 132374

132374

Page 2

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N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Saddle RH Out, 206

Stop *NS2*

Start Date: 5/07/15 Start Qty: 8.00

8

Cust Item ID:

Required Date: 5/07/15 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

10 _____ 21563

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.01

Hand Finishing

10 0 Jm15-6-3

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Memo

0.00

Powder Coating

m 131545.

START TIME:

2:40

OVEN TEMPERATURE:

320° FINISH TIME:

3:10

10 0 15-6-8

DAS 34 9-89

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval ☐	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Work Order ID 132374

132374

Page 3

May-07-15 2:34:47 PM

Item ID: D2932-2 Accept *N9000040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Saddle RH Out, 206
Start Date: 5/07/15 Start Qty: 8.00 *8* Cust Item ID:
Required Date: 5/07/15 Req'd Qty: 8.00 *8* Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							DAS 38 9-89
160						(10)			
QC	Memo	0.00							
Quality Control									JUN 09 2015
170	Identify as per dwg & Stock Location: ST-396	0.00							
170									
Packaging	Memo	0.00							
Packaging									JUN 09 2015
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.01							
Quality Control									JUN 11 2015

MLJ JUN 11 2015

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

May-07-15 2:34:46 PM

Page 1

Work Order ID: 132374

132374

Parent Item: D2932-2

D2932-2

Parent Item Name: Saddle RH Out, 206

Start Date: 5/07/15

Required Date: 5/07/15

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: B00.06.26New DWG rev (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-003

Manufactured No

100

Each

25,0000

1

8

**

8

DAS

20

9-89

15-05-27

D6101-003

Saddle Billet, 7075

Location

Loc Qty

Loc Code

MAT044

25

120394

1

128906

2

129920

6

130770

6

131023

10

2
4
2
4

DAS

44

9-89

15/05/28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QS1042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
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Root Cause		FAULT CATEGORY																							
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :																							
Misidentified ☐	Past Due ☐																								

DART AEROSPACE LTD	Work Order:	132374
Description: 206 Saddle, Outboard, Right side	Part Number:	D2932-2
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.114		.113	.112		
B	0.100	0.140		.115		.115	.115		
C	0.100	0.140		.115		.115	.115		
D	0.210	0.230		.219		.219	.218		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.511		.511	.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.238		.239	.238		
N	0.100	0.140		.120		.120	.119		
O	0.540	0.560		.548		.549	.548		
P	0.490	0.510		.500		.500	.500		
Q	3.715	3.725		3.718		3.719	3.720		
R	2.470	2.510		2.491		2.491	2.491		
S	0.240	0.270		.250		.251	.251		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.125	1.145		1.135	1.139	1.1345	1.134		
Y	1.565	1.585		1.576	1.579	1.575	1.574		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	44
Date:	15/05/28

Audited by:	
Date:	15-6-28

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Turning Sequence ☐																																																																						
OTHER : _____																																																																						

DART AEROSPACE LTD	Work Order:	132374
Description: 206 Saddle, Outboard, Right side	Part Number:	D2932-2
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5	6	7	8		
A	0.100	0.140		.112	.111	.113	.113		
B	0.100	0.140		.116	.116	.117	.116		
C	0.100	0.140		.115	.115	.115	.115		
D	0.210	0.230		.218	.219	.219	.219		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.511	.511	.511	.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.119	.119	.119	.119		
O	0.540	0.560		.548	.549	.549	.548		
P	0.490	0.510		.500	.497	.501	.500		
Q	3.715	3.725		3.718	3.719	3.719	3.720		
R	2.470	2.510		2.491	2.492	2.491	2.492		
S	0.240	0.270		.251	.250	.251	.251		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.125	1.145		1.134	1.136	1.134	1.135		
Y	1.565	1.585		1.5745	1.576	1.574	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	44
Date:	15/05/28

Audited by:	JK
Date:	15-6-3

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval
--------------	---------------	-----------------------	-----------------------

Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐								
Misidentified	☐	Past Due	☐	OTHER :							

DART AEROSPACE LTD	Work Order:	132324
Description: 206 Saddle, Outboard, Right side	Part Number:	D2932-2
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

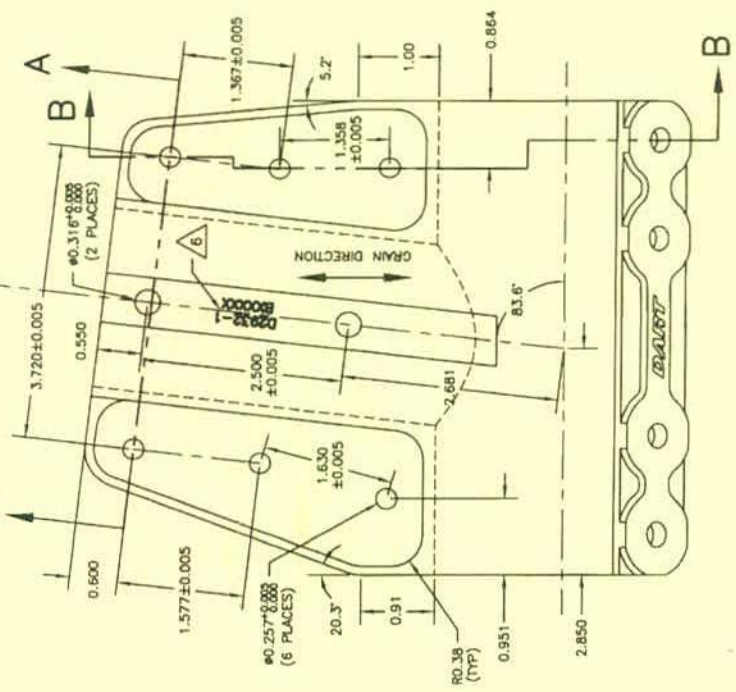
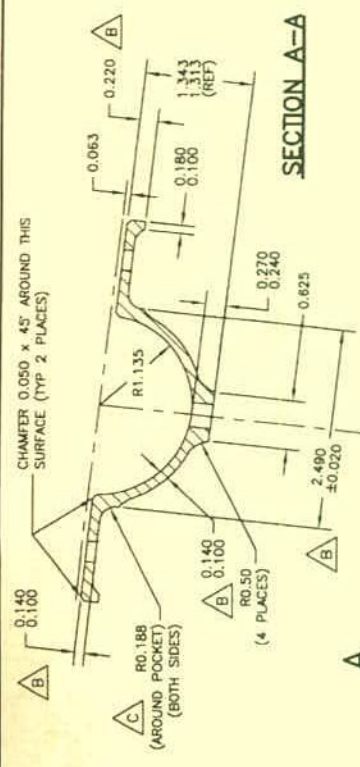
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				9	10	11	12		
A	0.100	0.140		.112	.112	.111	.112		
B	0.100	0.140		.116	.115	.114	.114		
C	0.100	0.140		.114	.115	.115	.115		
D	0.210	0.230		.221	.220	.220	.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.511	.511	.511	.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.121	.121	.120	.120		
O	0.540	0.560		.550	.550	.549	.547		
P	0.490	0.510		.500	.498	.498	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.492	2.491	2.491	2.491		
S	0.240	0.270		.251	.250	.251	.251		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.125	1.145		1.137	1.137	1.136	1.135		
Y	1.565	1.585		1.577	1.577	1.576	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	44
Date:	15/05/20

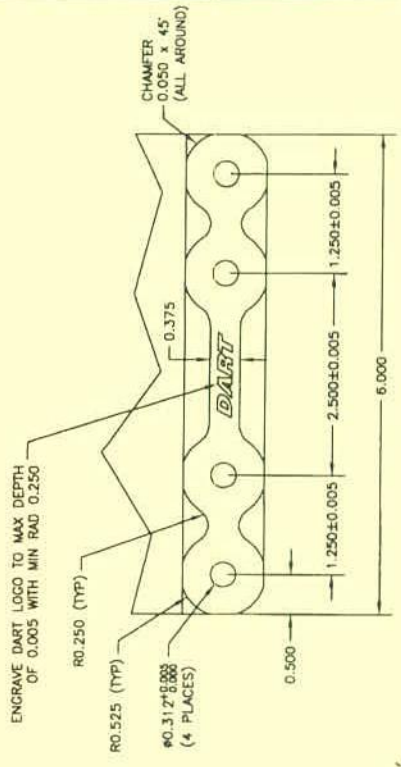
Audited by:	JL
Date:	15-6-3

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

w/0 132374



VIEW C-C



D2932-1 LH SADDLE (SHOWN)
D2932-2 RH SADDLE (OPPOSITE)

- NOTES:
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12) (MAKE FROM D6101-003 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	RO.188 WAS RO.30 TO RO.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE

DESIGN	APPROVED	DATE	06.11.09
DRW BY	CB	TITLE	SADDLE OUTSIDE
CHECKED	PH	DRAWING NO.	D2932
DART		DART AEROSPACE USA, INC.	
REV C		SHEET 1 OF 1	
SCALE		2:3	

07.02.02

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DART AEROSPACE USA, INC.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																		
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Part Number: D2932-2	Rev: C	- Page 1 -
Description: SADDLE OUTSIDE	Inspection Dwg: D2932	Work Order: 132374

Item Ref.	Nominal	Tolerance	3. No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	No. Piece_4 Actual	No. Piece_5 Actual
A	0.120	+0.020/-0.020	0.113	0.112	0.112	0.111	0.113
B	0.120	+0.020/-0.020	0.115	0.115	0.116	0.116	0.117
C	0.120	+0.020/-0.020	0.115	0.117	0.115	0.115	0.115
D	0.2200	+0.0100/-0.0100	0.2216	0.2208	0.2211	0.2215	0.2197
E	1.2500	+0.0050/-0.0050	1.2494	1.2502	1.2490	1.2496	1.2500
F	1.2500	+0.0050/-0.0050	1.2496	1.2518	1.2500	1.2500	1.2499
G	2.5000	+0.0050/-0.0050	2.4992	2.4978	2.4991	2.4995	2.4993
H	0.510	+0.005/0.000	0.511	0.511	0.511	0.511	0.511
I	1.5770	+0.0050/-0.0050	1.5778	1.5775	1.5777	1.5779	1.5777
J	2.5000	+0.0050/-0.0050	2.4990	2.4982	2.4991	2.4992	2.4994
K	0.2570	+0.0050/-0.0010	0.2577	0.2578	0.2577	0.2576	0.2578
L	0.3120	+0.0050/-0.0010	0.3129	0.3123	0.3129	0.3133	0.3134
M	0.235	+0.005/0.000	0.239	0.238	0.238	0.238	0.238
N	0.1200	+0.0200/-0.0200	0.1202	0.1195	0.1198	0.1203	0.1194
O	0.5500	+0.0100/-0.0100	0.5491	0.5485	0.5495	0.5501	0.5508
P	0.5000	+0.0100/-0.0100	0.5008	0.4996	0.5037	0.5048	0.5018
Q	3.7200	+0.0050/-0.0050	3.7183	3.7181	3.7180	3.7183	3.7191
R	2.4900	+0.0200/-0.0200	2.4927	2.4926	2.4928	2.4928	2.4927
S	0.255	+0.015/-0.015	0.251	0.251	0.251	0.250	0.251
T	0.140	+0.040/-0.040	0.135	0.135	0.135	0.135	0.135
U	1.6300	+0.0050/-0.0050	1.6304	1.6303	1.6291	1.6295	1.6302
V	1.3670	+0.0050/-0.0050	1.3674	1.3676	1.3673	1.3673	1.3681
W	0.3160	+0.0050/-0.0010	0.3152	0.3153	0.3150	0.3151	0.3153
X	1.135	+0.010/-0.010	1.135	1.134	1.134	1.136	1.134
Y	1.575	+0.010/-0.010	1.575	1.574	1.575	1.576	1.574
Z	0.1880	+0.0100/-0.0100	0.1958	0.1956	0.1946	0.1947	0.1955

Measured by:
Mathieu Lamarche

Date:
2015-6-2

Audited by:

Date:



Part Number: D2932-2	Rev: C	- Page 1 -
Description: SADDLE OUTSIDE	Inspection Dwg: D2932	Work Order: 132374

Item Ref.	Nominal	Tolerance	No. Piece_6 Actual	No. Piece_7 Actual	No. Piece_8 Actual	1. No. Piece_9 Actual	No. Piece_10 Actual
A	0.120	+0.020/-0.020	0.113	0.112	0.112	0.112	0.112
B	0.120	+0.020/-0.020	0.116	0.116	0.115	0.115	0.114
C	0.120	+0.020/-0.020	0.115	0.114	0.115	0.117	0.115
D	0.2200	+0.0100/-0.0100	0.2207	0.2228	0.2229	0.2208	0.2213
E	1.2500	+0.0050/-0.0050	1.2506	1.2497	1.2497	1.2502	1.2500
F	1.2500	+0.0050/-0.0050	1.2507	1.2496	1.2500	1.2518	1.2501
G	2.5000	+0.0050/-0.0050	2.4978	2.4983	2.4992	2.4978	2.4993
H	0.510	+0.005/0.000	0.511	0.511	0.511	0.511	0.511
I	1.5770	+0.0050/-0.0050	1.5777	1.5770	1.5787	1.5775	1.5777
J	2.5000	+0.0050/-0.0050	2.4996	2.4989	2.4986	2.4982	2.4991
K	0.2570	+0.0050/-0.0010	0.2575	0.2577	0.2574	0.2578	0.2574
L	0.3120	+0.0050/-0.0010	0.3126	0.3131	0.3133	0.3123	0.3127
M	0.235	+0.005/0.000	0.238	0.238	0.238	0.238	0.238
N	0.1200	+0.0200/-0.0200	0.1194	0.1219	0.1216	0.1195	0.1200
O	0.5500	+0.0100/-0.0100	0.5493	0.5511	0.5492	0.5485	0.5480
P	0.5000	+0.0100/-0.0100	0.5003	0.5014	0.4994	0.4996	0.4998
Q	3.7200	+0.0050/-0.0050	3.7175	3.7183	3.7183	3.7181	3.7191
R	2.4900	+0.0200/-0.0200	2.4926	2.4929	2.4930	2.4926	2.4939
S	0.255	+0.015/-0.015	0.251	0.251	0.250	0.251	0.251
T	0.140	+0.040/-0.040	0.135	0.135	0.135	0.135	0.135
U	1.6300	+0.0050/-0.0050	1.6297	1.6310	1.6292	1.6303	1.6301
V	1.3670	+0.0050/-0.0050	1.3678	1.3672	1.3678	1.3676	1.3680
W	0.3160	+0.0050/-0.0010	0.3150	0.3150	0.3150	0.3153	0.3150
X	1.135	+0.010/-0.010	1.135	1.137	1.137	1.134	1.135
Y	1.575	+0.010/-0.010	1.575	1.577	1.577	1.574	1.575
Z	0.1880	+0.0100/-0.0100	0.1957	0.1954	0.1954	0.1956	0.1926

Measured by:
Mathieu Lamarche

Date:
2015-6-2

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